

Work Order ID 164602

Tuesday, July 25, 2017 7:51:53 AM

164602

Page 1

Item ID: D4672-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blanking Plate
Start Date: 8/2/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/3/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUL 25 2017 Tooling: Date: Run Start ***NR1***
QC: 21 Date: SPC (Y/N): Date: Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4672	A								

100		0.02							DAS 40 9-89
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100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D4672

Dwg Rev: AProg Rev: A

2-Deburr as required

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.04

(4)

17/07/27

(4)

17/07/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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164602

Page 2

Item ID: D4672-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate

Start Date: 8/2/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/3/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						4			DAS 38
QC	Memo	0.08							JUL 28 2017
Quality Control									
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.04							
Packaging	LOCATION: WA004								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89

AUG 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
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Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
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Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

Tuesday, July 25, 2017 7:51:56 AM

Page 1

Work Order ID: 164602

164602

Parent Item: D4672-1

D4672-1

Parent Item Name: Blanking Plate

Start Date: 8/2/2017

Required Date: 8/3/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC IPP
REV:B 12.07.24 AS PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	52.8000	0.68	2.863158			DAS 40 9-89
M304S20GA									**			1707/27	
304/316 .040 Sheet													

Location

Loc Qty

Loc Code

MAT020

52.8

m137513

15.3

m137762

8.7

m137980

28.8

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

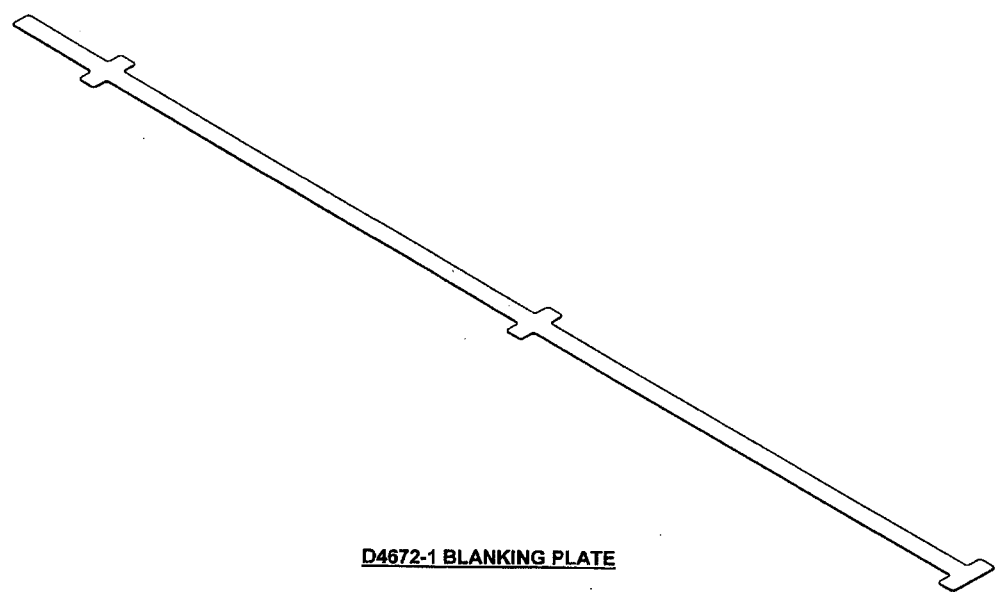
QA Closed: _____ Date: _____

Work Order update only ☐

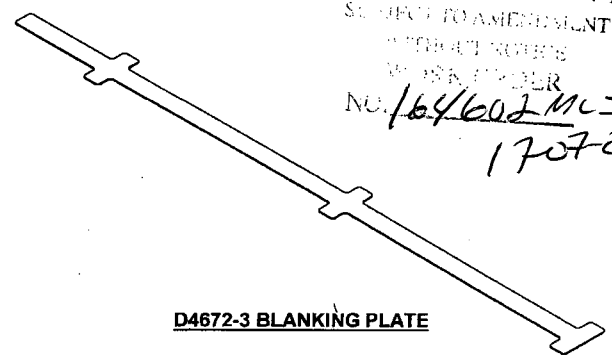
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8 7 6 5 4 3 2 1

D
C
B
A



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

SHOE COPY
 RE-DESIGNED
 RE-ENGINEERED
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 164/602 MJS
 170721

RELEASED
 2012-07-10
 4P ELN 12-611

A	NEW ISSUE	MB	12.06.13
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.06.13		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

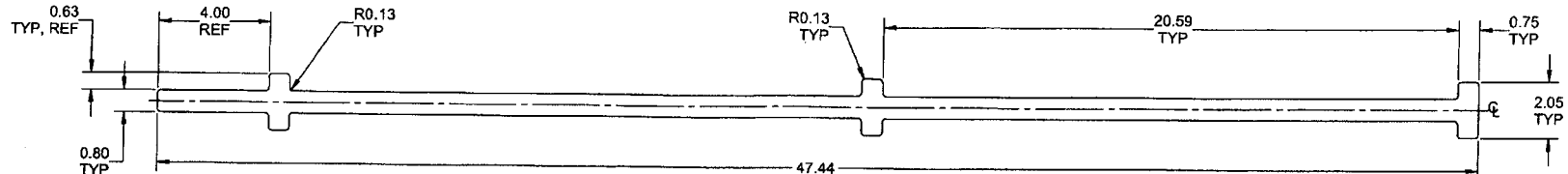
DRAWING NO. **D4672** REV. A
 SHEET 1 OF 2

TITLE **BLANKING PLATE** SCALE NTS

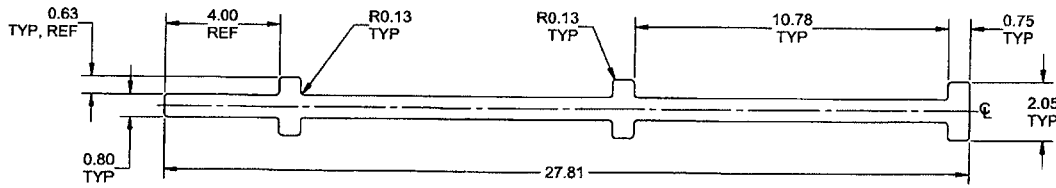
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4672-1 BLANKING PLATE



D4672-3 BLANKING PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4672-X" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4672-1 = 0.47 lbs; D4672-3 = 0.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE OF PART

RELEASED
2012-07-10
ECN 12-64

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4672	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE BLANKING PLATE	SCALE NTS
DE APPR.			
DATE	12.06.13		

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8 7 6 5 4 3 2 1